

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009061**Date Inspected:** 30-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Yumin, Chen Ying Xin, Liu XG			<b>CWI Present:</b> Ming,	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the trial assembly area:

2AW/2BW - ABF performing MT at the following locations: side plate to side plate I-rib, bottom plate to bottom plate I-rib welds, and upper floor beam web to upper flange welds.

2AE/2BE - ABF performing MT and grinding at the following locations: longitudinal diaphragm to bottom plate welds.

ZPMC CWI Xu Yumin (QC1) informed this QA Inspector, George Goulet, that ZPMC would be performing RT in the trial assembly area at 2200 hours. This QA Inspector left the area.

**Bay 10**

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint NSD1-FASA4-1B/E-5-26 located on north tower, lift 4, skin A. Welder was identified as 057244. ZPMC QC was identified as CWI Chen Ying Xin (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-4332-Tc-P4-F.

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## WELDING INSPECTION REPORT

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FCAW welding of weld joint NSD1-FASA4-1B/E-3-26 located on north tower, lift 4, skin A. Welder was identified as 052075. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint SSTL3-1K/K-18 located on south tower, lift 3, corner angle plate at skins C to D. Welder was identified as 050041. ZPMC QC was identified as CWI Li Ming (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2233-B-U2a-F.

### Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint ESTL3-4B/K-83B located on east tower, lift 3. Welder was identified as 040733. ZPMC QC was identified as CWI Liu Xiao Zhong (QC4). The welding variables recorded by QC4 appeared to comply with WPS-345-SMAW-4G(4F)-repair listed on ZPMC Repair Order I-CWR 210.

FCAW welding of weld joint WSD1-FASA4-2C/E-3, 4 located on west tower, lift 4. Welder as identified as 066471. ZPMC QC was identified as CWI Zhen Bo (QC5). The welding variables recorded by QC5 appeared to comply with WPS-B-T-345+485-FCAW-2G(2F)-repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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